

Work Order ID 56652

Wednesday, March 03, 2010 1:02:04 PM



Page 1

ASAP

Item ID: D3730-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Angle

Start Date: 3/3/2010 Start Qty: 10.00



Cust Item ID:

Required Date: 3/10/2010 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: MF Date: 10-3-3

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Draw Number | Draw Rev. | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|

Draw Nbr

Revision Nbr

D3730

Rev B

100

0.00



BAND SAW

Bandsaw

Memo

0.00

Jcaspa Bandsaw

Cut to Lenght as per Dwg D3730

JK 10/03/06

(10)

110

0.00



CONVENTIONAL MILLING MACHINE

Mill Conv

Memo

0.00

Conventional Milling Machine

1- drill holes as per dwg D3730-2-Deburr

JK 10/03/07

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

JK 10/03/07

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC8- Inspect parts - second check

0.00

QC

Memo

0.00

Quality Control

140

Small Fab

0.00

Small Fab

Memo

0.00

Small Fab

1- Grind radius as per dwg D3730□2- Deburr if necessary

150

QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control



10/03/04

10

10/03/07

5/10/08

40

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Required Date: 3/10/2010 Req'd Qty: 10.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

Chemical Conversion Coat per QS1005 4.1

0.00



HandFinish

Memo

0.00

el 10/05/08

Y 10

Ø

Hand Finishing

170

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

10-3-8-50

(100)

Quality Control

180

Identify as per dwg & Stock Location: Steven

0.00



Packaging

Memo

WA

0.00

10-3-8 54

(100)

Packaging

| W/O: | | WORK ORDER CHANGES | | | | | |
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Cust Item ID:

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Customer:

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Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/03/11

mf

10-3-10

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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NOTE: Date & initial all entries

Picklist Print

Wednesday, March 03, 2010 1:02:03 PM

Page 1

Work Order ID: 56652



Parent Item: D3730-1



Parent Item Name: Angle

Start Date: 3/3/2010

Required Date: 3/10/2010

Comments: IPP Rev:A 08-01-30 new issue DD verified by:
IPP Rev:B 08-03-19 chg to revB ecn 1158 DD verified by:

Start Qty: 10.00

Required Qty: 10.00

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Remaining Qty To Pick | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
| M6061T6A.750W.125 | | Purchased | No | | | 100 | f | 51.4700 | 1.7537 | | | |



angle .750 x .750 x .125w



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

51.47

18147

51.47

D6207-

1X1X.125w

46909

1.76

2L 10/03/07

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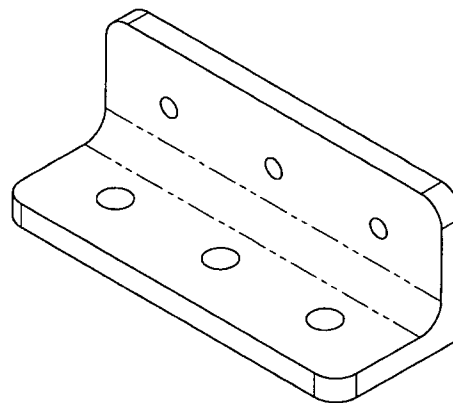
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NOTE: Date & initial all entries



D3730-1 ANGLE B

#36650

08.03.17 MP

NOTES:

- 1) MATERIAL: 6061-T6/T6510/T6511 ALUMINUM ANGLE, 0.75 X 0.75 X 0.125
PER AMS-QQ-A-200/8
(REF. DART SPEC. M6061T6A750XW125) B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.03 lbs

| B | SHEET 1 NOTES DART SPEC IN MATERIALS UPDATED, ISO VIEW UPDATED. SHEET 2 ZONE C4. Ø0.098 HOLES WERE Ø0.159, ZONE 7B 0.440 DIM WAS 0.450. | AJS | 08.03.06 |
|------------|---|---|----------|
| A | NEW ISSUE | AJS | 08.01.31 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | AJS | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | AJS | | |
| CHECKED | LE | DRAWING NO. REV. B | |
| MFG. APPR. | DS | D3730 SHEET 1 OF 2 | |
| APPROVED | MP | TITLE SCALE | |
| DE APPR. | MP | ANGLE NTS | |
| DATE | 08.03.06 | <small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small> | |

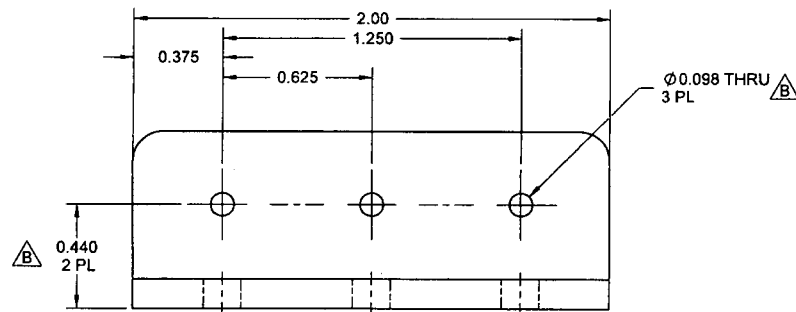
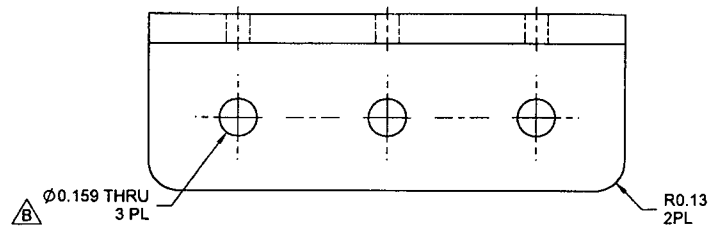
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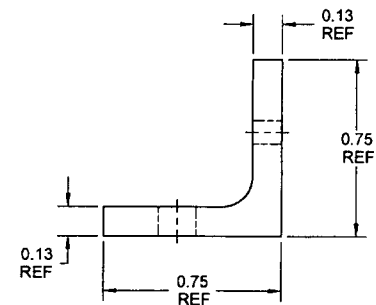
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D3730-1 ANGLE



#50652

08-03-17-11P

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|------------|----------|---|--------------|
| DESIGN | AJS | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | AJS | | |
| CHECKED | CE | DRAWING NO. | REV. B |
| MFG. APPR. | JS | D3730 | SHEET 2 OF 2 |
| APPROVED | JS | TITLE | SCALE |
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